

BLUE

Date: Wednesday, 03/09/2008 11:31:07 AM
User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: HELI ACCESS STEP LH
Job Number	: 41783		
Estimate Number	: 10855		
P.O. Number	:	Part Number	: D206628021BL
This Issue	: 03/09/2008	S.O. No.	:
Prsht Rev.	: NC	Drawing Number	: N/A - BLUE
First Issue	: / /	Project Number	: N/A
Previous Run	: 40926	Drawing Revision	: N/A
	Type : LARGE FAB ASSY	Material	:
Written By	:	Due Date	: 26/09/2008
Checked & Approved By	: <u>JLD 089.03</u>	Qty:	2 Um: Each
Comment	: Est Rev:D as per ECN 766 JLM Est Rev:E as per ecn 1118 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	DC	DOCUMENT CONTROL
Comment: DOCUMENT CONTROL Photocopy blue file and type labels as per PPP D206-628-021 CHG 002 <i>S 06/09/08</i>		
2.0	PACKAGING 1	PACKAGING RESOURCE #1
Comment: PACKAGING RESOURCE #1 Pick Packing Kit		
3.0	41783A	206L /407 STEP ASSY, LH
Comment: Sub-Component Step Assembly <i>S</i> <i>(x2)</i> 1 x D2724-041 Batch <u>41783A</u> <i>5/2</i>		
4.0	D2732030	Rubber Cushion
Comment: Qty.: 8.0000 Each(s)/Unit Total: 16.0000 Each(s) <i>S</i> <i>(x2)</i> Rubber Cushion batch <u>237632</u> <i>4 feet</i>		
5.0	AN414A	Bolt
Comment: Qty.: 4.0000 Each(s)/Unit Total: 8.0000 Each(s) <i>S</i> <i>(x2)</i> Bolt batch <u>M107534</u> <i>8/9/24</i> <i>50</i>		

W/O:		WORK ORDER CHANGES						
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 11:31:07 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: HELI ACCESS STEP LH

Job Number: 41783

Part Number: D206628021BL

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D27317

Mounting Lug



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D2731-7 BLUE Mounting Lug

41720

8/9/25

50

7.0

D3394043

Lug Assembly



Comment: Qty.: 4.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number Description Batch

4 D3394-043 BLUE LUG ASS,Y

41711

8/9/25

50

8.0

AN415A

Bolt



Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number Description Batch

8 AN4-15A Bolt

4106375

50

9.0

AN960JD416

Washer



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 AN960JD416 Washer

4108161

50

10.0

MS21042L4

Nut



Comment: Qty.: 12.0000 Each(s)/Unit Total : 24.0000 Each(s)

Pick:

Qty Part Number Description Batch

12 MS21042L4

Nut (or MS21042-4)

4107499

8/9/24

50

11.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

08/09/25 024H

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 11:31:07 AM
User: Julie Lecocq

Process Sheet

Customer : CH-DAF001 Dart Helicopters Services Drawing Name : HELI ACCESS STEP LH
Job Number : 41783
Estimate Number : 10855
P.O. Number : Part Number : D206628021BL
This Issue : 03/09/2008 S.O. No. : Drawing Number : N/A - BLUE
Prsht Rev. : NC Project Number : N/A
First Issue : / / Type : LARGE FAB ASSY Drawing Revision : N/A
Previous Run : 40926 Material :
Written By : Due Date : 26/09/2008 Qty: 2 Um: Each
Checked & Approved By : JUD 08.9.03
Comment : Est Rev:D as per ECN 766 JLM
Est Rev:E as per ecn 1118 DD verified by:EC

Additional Product

REFERENCE ONLY

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	DC	DOCUMENT CONTROL
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JUD 08.9.16



Comment: DOCUMENT CONTROL

Photocopy blue file and type labels as per PPP D206-628-021 CHG 002

2.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0	41783A	206L /407 STEP ASSY, LH
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Comment: Sub-Component Step Assembly

1 x D2724-041 Batch

4.0	D2732030	Rubber Cushion
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Comment: Qty.: 8.0000 Each(s)/Unit Total : 16.0000 Each(s)

Rubber Cushion

blue 628.024

Dart Aerospace Ltd.

Date: Wednesday, 03/09/2008 11:31:13 AM
 *Ser: Julie Lecocq

Process Sheet

Customer :	CU-DAR001 Dart Helicopters Services	Drawing Name :	206L /407 STEP ASSY, LH
Job Number :	41783A	Part Number :	D2724041
Estimate Number :	11702	Drawing Number :	D2724 REV C
P.O. Number :		Project Number :	N/A
This Issue :	03/09/2008	S.O. No. :	
Prsht Rev. :	NC	Drawing Revision :	C
First Issue :	/ /	Material :	
Previous Run :	40926A	Due Date :	26/09/2008
Written By :		Qty:	2
Checked & Approved By :	JUD 08.09.03	Um:	Each
Comment :	Est Rev:E As Per Ecn 766 06-01-06 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2622120C	Step Extrusion
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 2.0000 Each(s)

Qty	Part #	Description	Batch:
1	D2622-120C	Extrusion	B40937

Check Material for any Dents or Defects

SP 08.09.04

(2x)

2.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

Cut D2724-1 using D2622 extrusion as per Dwg D2724
 Deburr and bevel ends for welding

SP 08.09.04

(2x)

3.0	D2734	Step End Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

206 Step Endplate

Pick:

Qty	Part Number	Description	Batch
2	D2734	End Cap	B39179

SP 08.09.04

(4x)

4.0	D34581	Step Mounting Plate
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Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty	Part Number	Description	Batch
2	D3458-1	Plate	B36408

SP 08.09.04

(4x)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 11:31:13 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 41783A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D34583

Step Mounting Plate



Comment: Qty.: 2.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

2 D3458-3

Description

Plate

Batch

~~B3412~~ B362409

SP 08.09.04

6.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Weld end cap and lugs as per Dwg D2724 using Jig DT8884 followed by Jig

DT (One End Only)

A/R AL ROD

Batch:

108350
108037

SP 08.09.08

Grind end cap welds flush

SP 08.09.08

7.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

8.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/09/05 424H

9.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAN 08/09/15

10.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

M 08/09/16 24

11.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

Inspect for foreign object per QSI 024

SP 08.09.16 200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 11:31:14 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 41783A

Part Number: D2724041

Job Number:



Seq. #: Machine Or Operation: Description :

Weld Remaining end cap as per Dwg D2724 using Jig DT followed by Jig

DT

A/R AL ROD Batch: 108037

Grind per dwg D2724

SAD

08/09/17 (2x) SP: 08.09.16 (2x)

12.0

QC9



Comment: VISUAL WELDING INSPECTION

08-09-17

13.0

QC5



INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SAD 08/09/17 (2x) LH

14.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Touch up Alodine

M. 08/09/17

15.0

SPRAY PAINTING

SPRAY PAINTING



Comment:

-PRIME

B106729

-SPRAY PAINT DELFLEET BLUE

B105918

-CLEAR DELFLEET

B109333

ml 08.09.23 (2)

16.0

QC14



INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

S 08/09/25 (2x) LH

17.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: Wing Walk as per Dwg D2724 and QSI 00 5 4.4

ml 08-09-25 (2x) LH

18.0

QC3



INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FR 08/09/25 (2)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 03/09/2008 11:31:14 AM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206L /407 STEP ASSY, LH

Job Number: 41783A

Part Number: D2724041

Job Number:



Seq. #:

Machine Or Operation:

Description :

19.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

PPP 41783 *Sept 20 (7)*

20.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

①
2008/09/26

Job Completion



MF 08-09-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

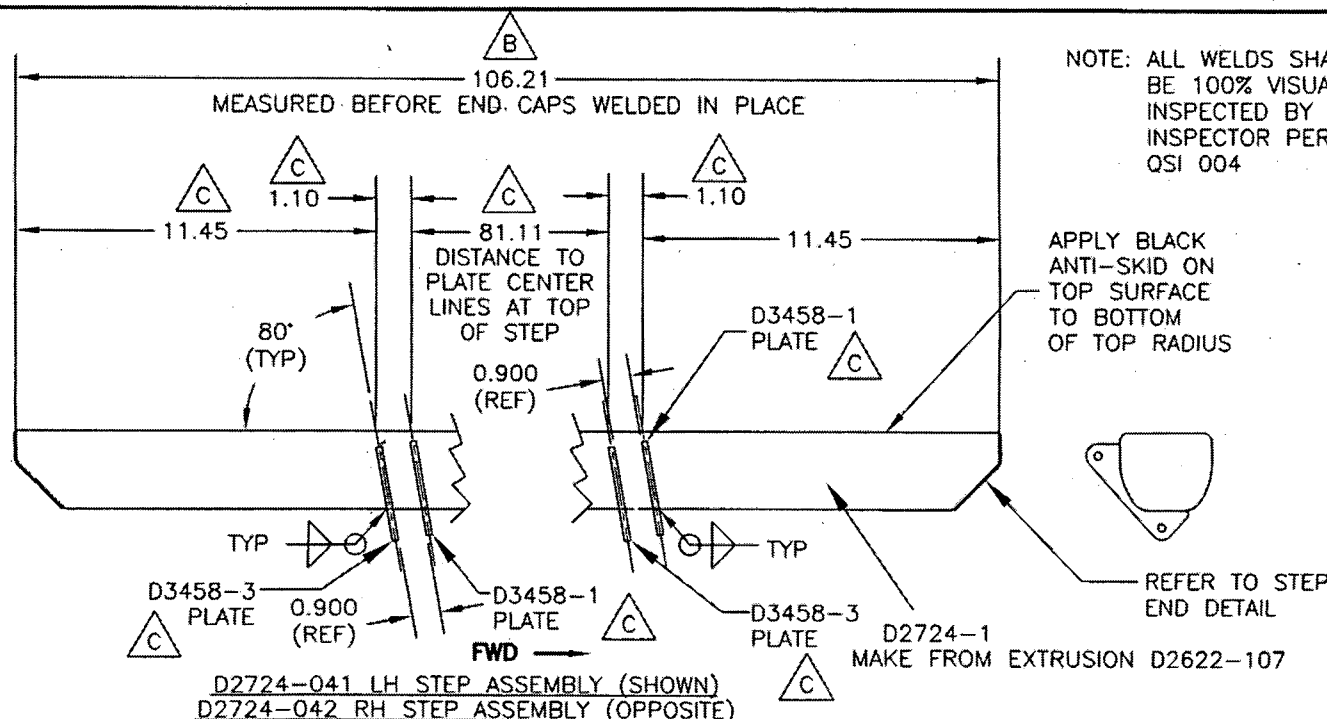
NOTE: Date & initial all entries

DART

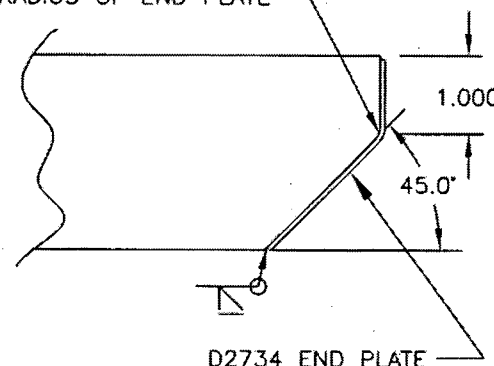
RELEASED
05.11.14

DESIGN	DRAWN BY	DART AEROSPACE USA, INC.
KE	PH	PORT HADLOCK, WA
CHECKED	APPROVED	DRAWING NO.
		D2724
DATE	TITLE	SCALE
05.09.19	206L/407 STEP ASSEMBLY	NTS
A	97.12.04	NEW ISSUE
B	98.10.19	UPDATED WELD DETAIL REVISED TOLERANCES
C	05.09.19	RE-DESIGN, ADD D3458-1/-3

NOTE: ALL WELDS SHALL
BE 100% VISUALLY
INSPECTED BY A QUALIFIED
INSPECTOR PER DART
QSI 004



ROUND CORNER OF EXTRUSION TO
MATCH BEND RADIUS OF END PLATE



TYPICAL STEP END DETAIL
NOT TO SCALE

D2721-041/-042 STEP ASSEMBLY PARTS LIST

QTY	QTY	PART NUMBER	DESCRIPTION
- 041	- 042		
X	X	D2724-041	LH STEP ASSEMBLY
		D2724-042	RH STEP ASSEMBLY
1	1	D2622-107	EXTRUSION
2	2	D2734	END PLATE
2	2	D3458-1	PLATE
2	2	D3458-3	PLATE

D2724-041/-042 STEP ASSEMBLY

- 1) MAKE FROM EXTRUSION D2622
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
APPLY BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) ALL TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

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NO. 47839